

Work Order ID 61237

Wednesday, August 11, 2010 11:31:42 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 8/12/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 10-9-1

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-9-1

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

JH-03
A1272.

12

100522

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 8/12/2010 Start Qty: 12.00

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Reference:

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: FP-10

0.00

eu 10/09/03

0.00

12 0

Memo

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/09/02 JD
mk
10-9-02

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61237



Parent Item: D3536-23



Parent Item Name: Gasket

Start Date: 8/12/2010

Required Date: 8/26/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	222.7233	1.3365	16.88211			



NEOPRENE SHEET 0.063



B10-9-1

Location

Loc Qty

Loc Code

MAT

117.4702

115500

114691

117.4702

MAT052

105.2531

114176

105.2531

W/O:		WORK ORDER CHANGES					
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
DART AEROSPACE LTD		Work Order:	61237
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

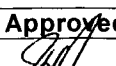
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	x		T	
48.20	+/-0.030	48.20	o		T	
44.70	+/-0.030	44.70	b		T	
39.31	+/-0.030	39.31	x		T	
33.92	+/-0.030	33.92	x		T	
28.53	+/-0.030	28.53	o		T	
23.14	+/-0.030	23.14	x		T	
17.75	+/-0.030	17.75	x		T	
14.25	+/-0.030	14.25	x		T	
9.50	+/-0.030	9.50	s		T	
4.75	+/-0.030	4.75	v		T	
8.00	+/-0.030	8.00	u		T	
16.00	+/-0.030	16.00	u		T	
24.00	+/-0.030	24.00	u		T	
32.00	+/-0.030	32.00	x		T	
39.00	+/-0.030	39.00	x		T	
48.00	+/-0.030	48.00	x		T	
0.30	+/-0.030	.301	x		V	B02
0.30	+/-0.030	.303	x		V	
1.89	+/-0.030	1.888	x		V	
Ø0.19	+0.005/-0.001	.190	x		V	

Measured by:	B
Date:	10-9-1

Audited by:	
Date:	1009-02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

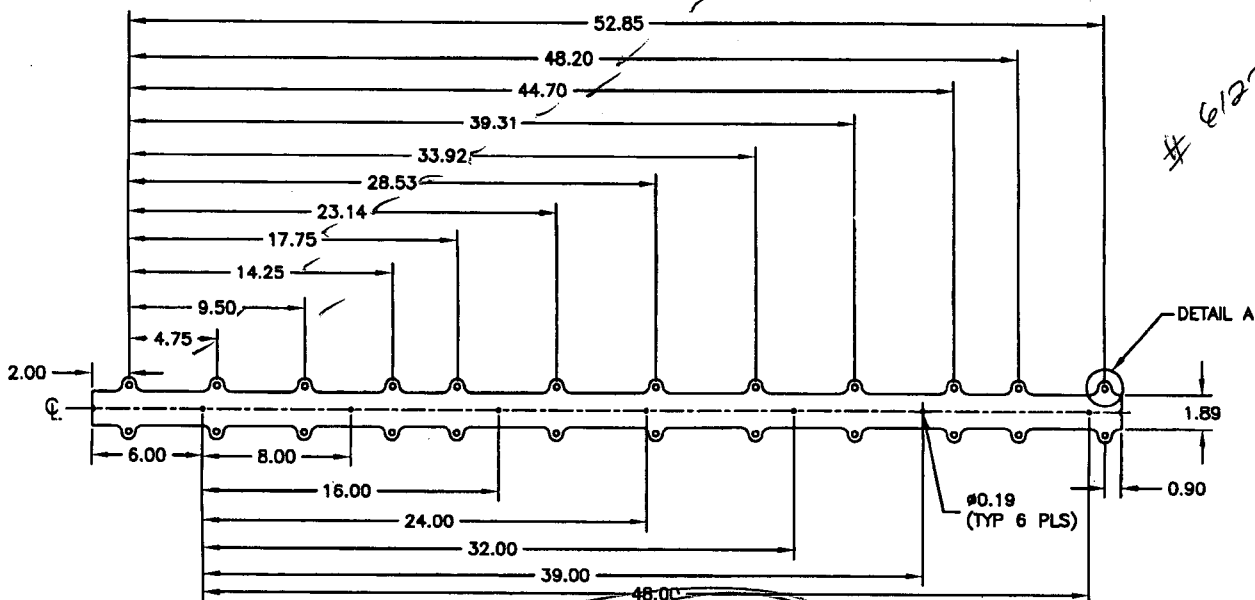
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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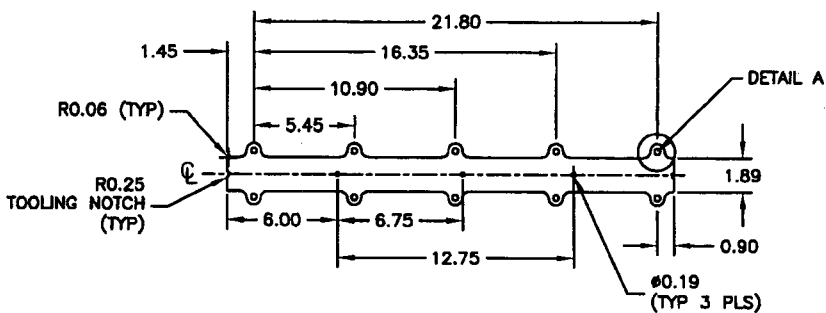
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 3 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10



D3536-23 GASKET



D35.36-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

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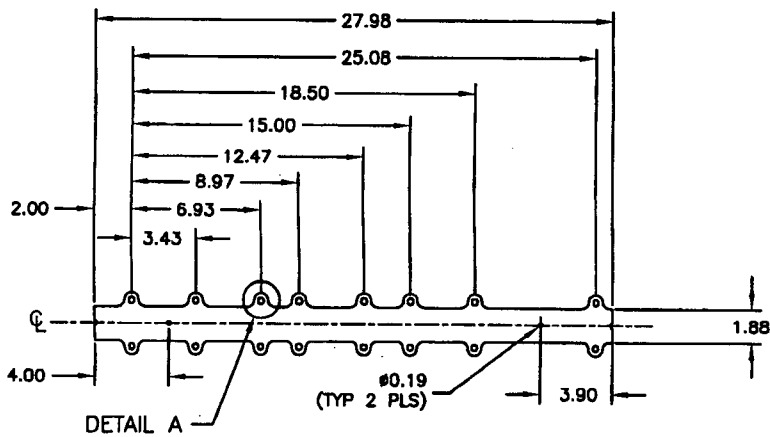
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 6 OF 6
		SCALE	1:10	

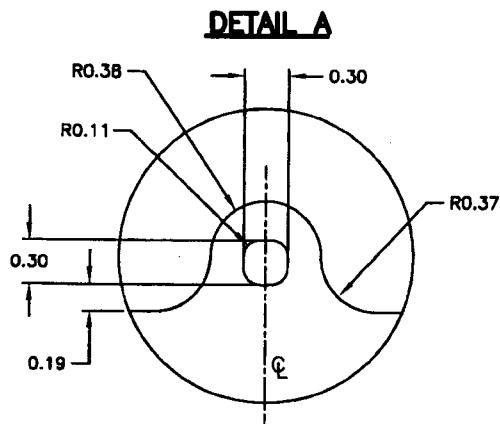
#61237
07.02.12
RECEIVED



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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